

104312

FORM U-1A MANUFACTURER'S DATA REPORT FOR PRESSURE VESSELS
 (Alternative Form for Single Chamber, Completely Shop-Fabricated Vessels Only)
 As Required by the Provisions of the ASME Code Rules, Section VIII, Division 1

1. Manufactured and certified by Roben Mfg. Co., Inc. 760 Vassar Avenue Lakewood NJ 08701
 (Name and address of manufacturer)
2. Manufactured for Glitsch Technology Corp. 1055 Parsippany Blvd., Suite 503 Parsippany NJ 07054
 (Name and address of purchaser)
3. Location of installation Hoechst Celanese 4600 Highway 421 North Wilmington NC 28402
 (Name and address)
4. Type Vertical 95040 C-95040 9091 1995
 (Horiz. or vert., tank) (Mfr's serial No.) (ICRN) (Drawing No.) (Nat'l. Bd. No.) (Year built)
5. The chemical and physical properties of all parts meet the requirements of material specifications of the ASME BOILER AND PRESSURE VESSEL CODE. The design, construction, and workmanship conform to ASME Rules, Section VIII, Division 1 1992
 Year
- to A93 Code Case Nos. Special Service per UG-120(d)
 Addenda (Date)
6. Shell: SA240T316L 3/8" .125" 5'-0" O.D. 12'-0"
 Matl. (Spec. No., Grade) Nom. Thk. (in.) Corr. Allow. (in.) Diam. I.D. (ft. & in.) Length (overall) (ft. & in.)
7. Seams: Dbl. Spot 85 - - Dbl. - 1
 Long. (Welded, Dbl., Sngl., Lap, Butt) R.T. (Spot or Full) Eff. (%) H.T. Temp. (°F) Time (hr) Girth (Welded, Dbl., Sngl., Lap, Butt) R.T. (Spot, Partial, or Full) No. of Courses
8. Heads: (a) Matl. SA240T316L (b) Matl. SA240T316L
 (Spec. No., Grade) (Spec. No., Grade)

	Location (Top, Bottom, Ends)	Minimum Thickness	Corrosion Allowance	Crown Radius	Knuckle Radius	Elliptical Ratio	Conical Apex Angle	Hemispherical Radius	Flat Diameter	Side to Pressure (Convex or Concave)
(a)	Top	.4650	.125"	60"	4:5	-	-	-	-	concave
(b)	Bottom	.4650	.125"	60"	4:5	-	-	-	-	concave

If removable, bolts used (describe other fastenings)

(Matl., Spec. No., Gr., Size, No.)

9. MAWP FV/50 600 °F
 psi at max. temp.
 Min. design metal temp. -20 °F at FV/50 psi. Hydro. xxxxxx test pressure 90 psi.

10. Nozzles, inspection and safety valve openings:

Purpose (Inlet, Outlet, Drain)	No.	Diam. or Size	Type	Matl.	Nom. Thk.	Reinforcement Matl.	How Attached	Location
Pump Outlet	1	8"	150# S.O. Flange	SA182T316L	.375	None	Welded	
Inlet	1	6"	150# S.O. Flange	SA182T316L	.375	None	Welded	
Vent	1	3"	150# S.O. Flange	SA182T316L	.300	None	Welded	
Manway	1	20"	flat face flg. w/clad	SA105&SA240T316L	.375	SA240T304	welded	Shell

11. Supports: Skirt No (Yes or no) Lugs - (No.) Legs four (No.) Other Stiffening Ring Attached Welded on shell with R. Pad.
 (Describe) (Where and how)

12. Remarks: Manufacturer's Partial Data Reports properly identified and signed by Commissioned Inspectors have been furnished for the following items of the report:

(Name of part, item number, Mfr's name and identifying stamp)

Unit will be used as 60" O.D. T316L suction drum. Non lethal service.

Exempt from impact testing per code paragraphs UG-20(f) & UHA-51, UCS-66

Prior to placing the vessel in service safety valves to be fitted.

CERTIFICATE OF SHOP COMPLIANCE

We certify that the statements made in this report are correct and that all details of design, material, construction, and workmanship of this vessel conform to the ASME Code for Pressure Vessels, Section VIII, Division 1. "U" Certificate of Authorization No. 24,584 expires 1/5, 1996.
 Date 3-17-95 Co. name Roben Mfg. Co., Inc. Signed Andrew Math
 (Manufacturer) (Representative)

CERTIFICATE OF SHOP INSPECTION

Vessel constructed by Roben Mfg. Co., Inc. at Lakewood, New Jersey.
 I, the undersigned, holding a valid commission issued by the National Board of Boiler and Pressure Vessel Inspectors and/or the State or Province of New Jersey and employed by Kemper National Insurance Companies
 have inspected the component described in this Manufacturer's Data Report on MAR 17 1995, 1995, and state that, to the best of my knowledge and belief, the Manufacturer has constructed this pressure vessel in accordance with ASME Code, Section VIII, Division 1. By signing this certificate neither the Inspector nor his employer makes any warranty, expressed or implied, concerning the pressure vessel described in this Manufacturer's Data Report. Furthermore, neither the Inspector nor his employer shall be liable in any manner for any personal injury or property damage or a loss of any kind arising from or connected with this inspection.
 Date MAR 17 1995 Signed [Signature] Commissions NB-7050AB, NJ 476
 (Authorized Inspector) (Nat'l. Board (incl. endorsements), State, Prov. and No.)

NOZZLE SCHEDULE					
MARK	QUAN.	SIZE	ASA RATING	SCH	SERVICE
A	1	8"	150 SLIP-ON W/RF	3/8"	PUMP OUTLET
B	1	6"		3/8"	INLET
C	1	3"		80	VENT
D	1	20"	W/FF	3/8"	MANWAY

- NOTES**
- CONSTRUCTION TO COMPLY WITH ASME CODE SECTION VIII ED. INCLUDING CERT. & STAMP FOR INSTALLATION IN STATE OF N.J.
 - NAME PLATE STAMPING:

U NATL. BD. **W** **CERTIFIED BY ROBEN MFG. CO. INC. LAKEWOOD N.J. 08701**

VESSEL MAWP FV/50 PSI AT 600 °F
 MIN DESIGN METAL TEMP -20 °F AT FV/50 PSI
 JACKET MAWP PSI AT °F
 MIN DESIGN METAL TEMP °F AT PSI
 TUBE MAWP PSI AT °F
 MIN DESIGN METAL TEMP °F AT PSI
 SERIAL NO. 95040 YEAR 1995

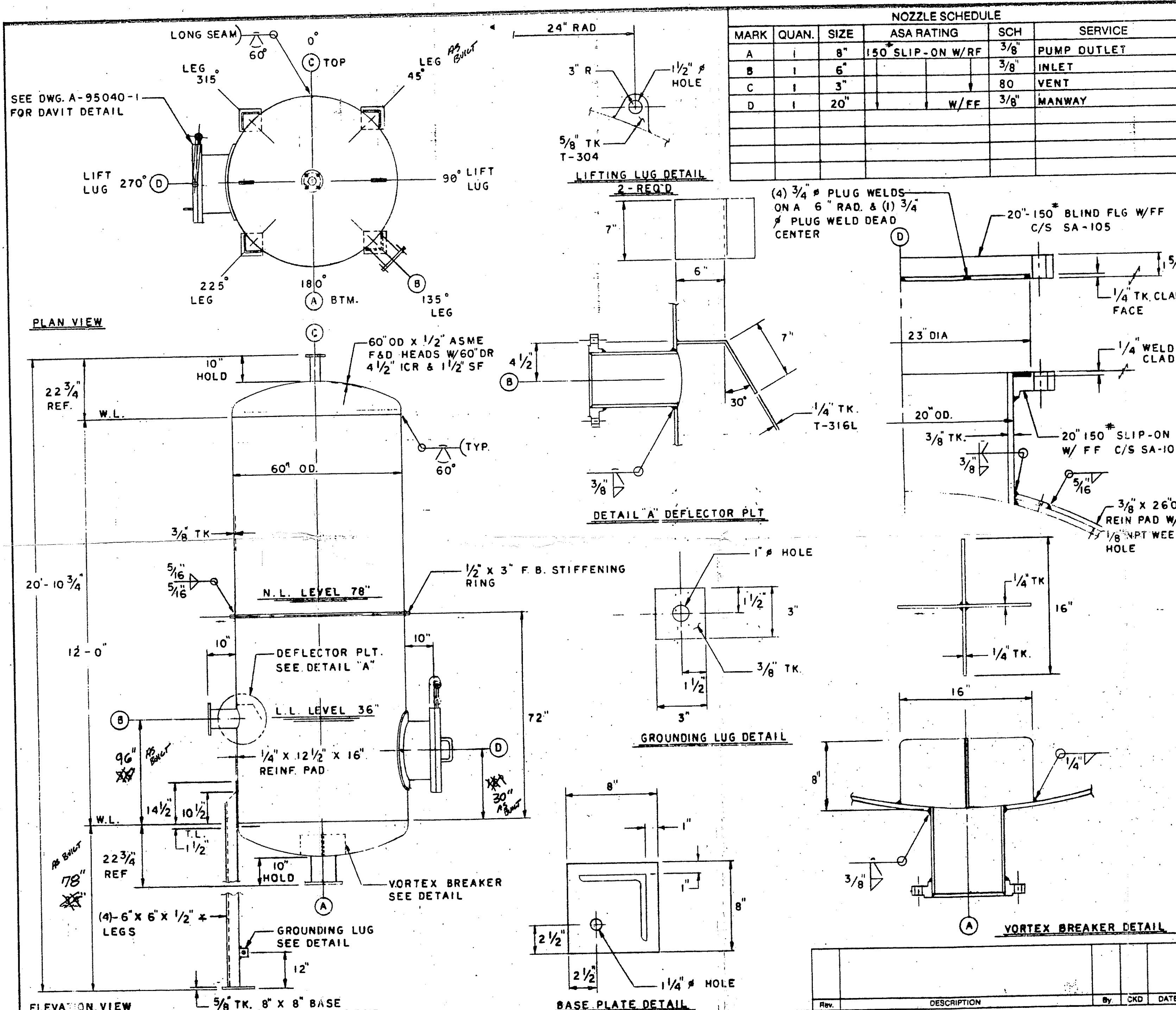
- SHELL SIDE
TEST PRESSURE 90 PSI
CORROSION ALLOW. 1/8"
- WEIGHTS:
EMPTY 5525 LBS.
FULL OF WATER 23047 LBS.
- PAINT: REFER TO NOTE NO. 4
SANDBLAST: NO
- STRESS RELIEVE: NO
- RADIOGRAPHY: YES SPOT X-RAY LONG SEAM
- SPECIAL TESTS: NO
- CUSTOMER'S INSPECTION: NO

- GENERAL NOTES —**
- ALL BOLT HOLES TO STRADDLE MAIN CENTER LINES.
 - VESSEL TO BE FREE OF ALL WELD SPLATTER, DIRT, OIL, AND GREASE.
 - COVER AND PLUG ALL OPENINGS FOR SHIPMENT.
 - PAINT ALL EXTERNAL C/S SURFACES WITH COAT OF CARBO ZINC II

VPF No. : 38141WN
 Equipment No. : T-1212-12
 Project No. : 27-0188
 P.O. No. : 32532
 Approved by : P. JOHNSON
 Sheet No. : 1
 Account No. : 4009
 Date : 9/15/95

CERTIFIED PRINT
 APPROVED FOR CONSTRUCTION BY AS BUILT 3-20-95 C. H. HARRIS
 CUSTOMER: GLITSCH TECHNOLOGY CORP.
 P.O. NO. 30158
 UNITS REQ'D (1) ONE #104312

ROBEN Manufacturing Company, Inc.
 60" OD T-316L SUCTION DRUM
 2000 GAL. T-1212-12
 SCALE 1/2" = 12" MADE RED GH 3-10-95 C-95040
 VPF # 38141WN



SHELLS				FACINGS				BONNETS/JACKETS				FACINGS				BOLTING CAD. PLT.				GASKETS 1/8" TK			
PIPE				EXPANSION JOINT				WELD CAPS				COVERS				SA-193 GR 87				COMPRESSED ASBESTOS			
ROLLED PLATE	316L	SA-240		END PLATE				FORMED HEADS				COVERS				SA-325				TEFLON			
BAFFLES				WELD CAPS				PIPE				TUBESHEETS				SA-320				FLEXITALLIC CGI			
TIE RODS				FORMED HEADS	316L	SA-240		ROLLED PLATE				TUBES								316L W/ GRAPHITE			
SPACERS				UNIT FLANGES				UNIT FLANGES				STIFF RING	304	SA-479		NUTS				FILLER			
NOZZLE FLGS	316L	SA-182	VORTEX BREAK					NOZZLE FLGS				REIN RADS	304	SA-240		SA-194 GR 2H				O-RINGS			
NOZZLE NECKS	316L	SA-312	SUPPORTS	ST'L	SA-36			NOZZLE NECKS				GROUND LUG	304	SA-240		SA-325							